

Date: Thursday, 02/10/2008 10:34:21 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 42407	
Estimate Number : 10600	
P.O. Number :	Part Number : D2519
This Issue : 02/10/2008 S.O. No. :	Drawing Number : D2519 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 41430	Material :
Written By :	Due Date : 15/10/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JUL 08.10.02</u>	
Comment : Est: B 00.03.16 Re-format, laser cutting EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 7299~~Laser cut~~ as per Dwg D2519

Material release note required

GFI

C 208/10/02 (50)

2.0	D2519F	Clamp
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

R 8/12/23 (50)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

(8.561" center to center)

508/10/23 (K50) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr any rough edges after tumbling

2-Bend as per Dwg D2519

n/h 5/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 10:34:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 42407

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



PD

Comment: INSPECT WORK TO CURRENT STEP

Sosluks counter

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

850

Tumble

HB 8-11-10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



SD

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 451

8/11/10

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
01/10/10	# 6 & 7	change orientation of steps # 6 and 7. tumble should be before inspect QC 5				<i>[Signature]</i> 08-11-10	<i>S</i> 08/11/10	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

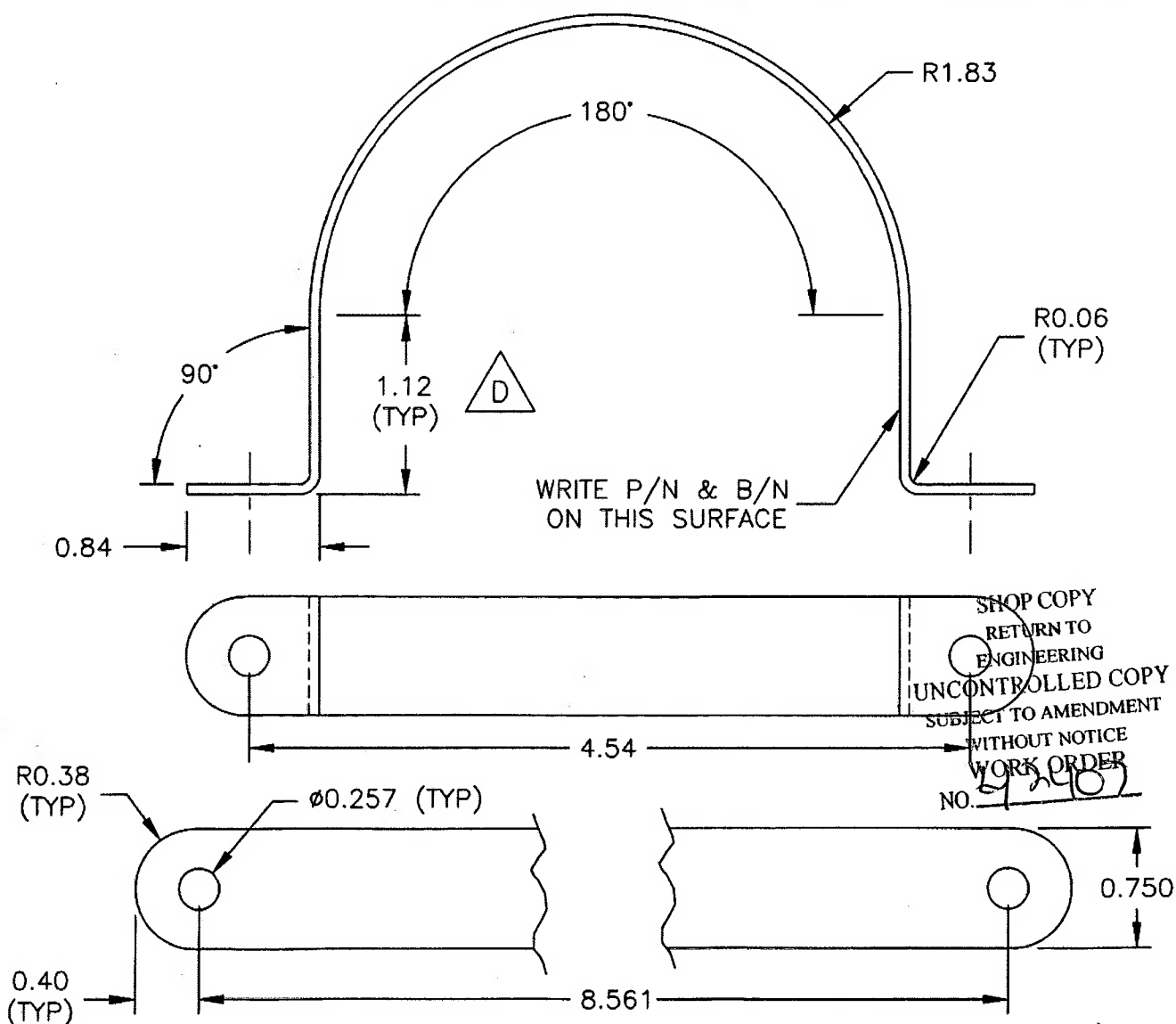
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED
04.11.26 *[Signature]***D2519 FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **4** OUR JOB NO **J0191902** SHIPPING MEMO **0406147**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	50 PCS	PO00007299	D2519F	D	CLAMP	D

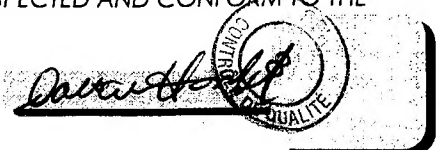
MATERIAL **S.S.T 304** SUPPLIED BY **SAMUEL / AK STEEL** MAT. REL. NO. **7380365 ATT'D**

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **22 OCTOBER 2008**

G.F.I. Q.C. REP.



**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRÉ DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 19 SEPTEMBRE 2008

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

Client: CC03625
Customer's order #:

de commande SSMQ: 883582
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:


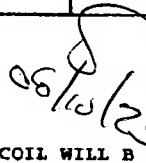

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
2	15	.060" X 48" X 96"	304 2B		7360365

Bien à vous,
Yours truly,



Marc Grippetto

Commis à l'administration.
Administration Clerk.

		AK Steel Corporation Metallurgical Test Report Rockport Works Rockport, IN 47635		Page 1												
				Load No. 8970283 SRN No. 8970283												
C U S T O M E R	SAMUEL & FILS & CIE LTEE (S) PUR DEPT 2225 FRANCIS HUGHES DRIVE LAVAL, CN H7S1N 5		S H I P T O	SAMUEL & FILES (QUEBEC) LTEE 2225 FRANCIS HUGHES LAVAL, CN H7S1N-5		MILL ORDER NO. 252502-1172 PART NO.	PROCESSOR ORDER NO. C10360-3	BUYERS ORDER NO. C10360-3								
	ENGLISH UNITS --PRODUCT-- METRIC UNITS .0590 NOM 48.0000 X COIL															
COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID											
127733-01BAAB	1	7380365	0127733-01BAA	19,960 LBS. 9,054 KG.	466346002											
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT												
1	1			19,960 LBS. 9,054 KG.												
L-Ladle Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS																
ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7380365	.023	1.240	.025	.0026	.385	18.11	8.09	.29	.0330	.44						
SHIPPING DATE: 06/14/2008 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL MATERIAL FREE OF RADIOACTIVE ISOTOPES																
PRODUCT DESCRIPTION CR SHT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -07 * ASTM A 480 -06 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASME SA-480 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASTM A 262 -02A2 PRACTICE E * ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES.																
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front								
0127733-01BAA	T	T	A.S.T.M	58.8	98.6	45.1	B 83	B 84								
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT											
0127733-01BAA	T		A.S.T.M	PASS	PASS											
THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS QUANTIFIED IN THE RECORDS OF THE CORPORATION. ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED AK Steel Corporation MW/CORPORATION						THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK Steel Corporation. TO AVOID THE POSSIBILITY OF ITS ABUSE, ON DELIVERY OF THE REPORT TO A THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE. SIGNED:  DATE 06/16/2008 TIME 05:57 AM RYAN MARTIN QUALITY MANAGER										